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**RBE703A95-0508-00-15**

**Job Sheet 196132**



**Part No:** RBE703A95-0508-00-15

**Job Qty:** 24 pcs

**Part Name:** MGB Drain Tube Quill Assembly



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 6/7/19

**Job Tracking No:**

**Due Date:** 6/14/19

**Created By:** Linda Lacelle

**Type:** Stock

**Description:**

**Note:** DWG RBE703A95-0508-00 Rev.J IPP Rev. A 19.03.06 New issue DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No     | Operation                   | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                         |
|-----------|-----------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------------------------------|
|           |                             |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                                  |
| 110       | Small Fab - 1               | 24 pcs | 6/14/19    |          | 0.00      | 4.80    | Small Fab - 1         |           | MLL                              |
|           |                             |        |            |          |           |         | Small Fab - 2         |           |                                  |
|           |                             |        |            |          |           |         | Small Fab - 3         |           |                                  |
|           |                             |        |            |          |           |         | Small Fab - 4         |           |                                  |
|           |                             |        |            |          |           |         | Small Fab - 5         |           |                                  |
|           |                             |        |            |          |           |         | Small Fab - 6         |           |                                  |
|           |                             |        |            |          |           |         | Small Fab - 7         |           |                                  |
| 120       | QC 5                        | 24 pcs | 6/14/19    |          | 0.00      | 0.00    | QC 5 - 10             |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 12             |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 17             |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 18             |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 19             |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 22             |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 24             |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 3              |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 43             |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 49             |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 51             |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 58             |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 68             |           |                                  |
|           |                             |        |            |          |           |         | QC 5 - 9              |           |                                  |
| QC 5 - 50 |                             |        |            |          |           |         |                       |           |                                  |
| QC 5 - 30 |                             |        |            |          |           |         |                       |           |                                  |
| QC 5 - 40 |                             |        |            |          |           |         |                       |           |                                  |
| 130       | Packaging 3-1 - Stock - B4B | 24 pcs | 6/14/19    |          | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           | DAS<br>40<br>9-89<br>JUN 17 2019 |
|           |                             |        |            |          |           |         | Packaging 3 - 2 - B4B |           |                                  |
|           |                             |        |            |          |           |         | Packaging 3 - 3 - B4B |           |                                  |
|           |                             |        |            |          |           |         | Packaging 3 - 4 - B4B |           |                                  |
|           |                             |        |            |          |           |         | Packaging 3 - 5 - B4B |           |                                  |
|           |                             |        |            |          |           |         | Packaging 3 - 6 - B4B |           |                                  |
|           |                             |        |            |          |           |         | Packaging 3 - 7 - B4B |           |                                  |



**Container No:** S191040

**Part:** RBE703A95 - 0508 - 00 - 15  
**Job No:** 196132

**Serial No/Batch:** S191040

**Revision:** J

**Inspector:**

**Exp Date:**

**Instructions:**

Date: 06/17/19

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|                |        |         |           |                        |                |
|----------------|--------|---------|-----------|------------------------|----------------|
|                |        |         |           | Packaging 3 - 8 - B4B  |                |
|                |        |         |           | Packaging 3 - 9 - B4B  |                |
|                |        |         |           | Packaging 3 - 10 - B4B |                |
|                |        |         |           | Packaging 3 - 11 - B4B |                |
|                |        |         |           | Packaging 3 - 12 - B4B |                |
|                |        |         |           | Packaging 3 - 13 - B4B |                |
|                |        |         |           | Packaging 3 - 14 - B4B |                |
|                |        |         |           | Packaging 3 - 15 - B4B |                |
|                |        |         |           | Packaging 3 - 16 - B4B |                |
|                |        |         |           | Packaging 3 - 17 - B4B |                |
|                |        |         |           | Packaging 3 - 18 - B4B |                |
|                |        |         |           | Packaging 3 - 19 - B4B |                |
|                |        |         |           | Packaging 3 - 20 - B4B |                |
|                |        |         |           | Packaging 3 - 21 - B4B |                |
|                |        |         |           | Packaging 3 - 22 - B4B |                |
|                |        |         |           | Packaging 3 - 23 - B4B |                |
|                |        |         |           | Packaging 3 - 24 - B4B |                |
|                |        |         |           | Packaging 3 - 25 - B4B |                |
|                |        |         |           | Packaging 3 - 26 - B4B |                |
|                |        |         |           | Packaging 3 - 27 - B4B |                |
|                |        |         |           | Packaging 3 - 28 - B4B |                |
|                |        |         |           | Packaging 3 - 29 - B4B |                |
|                |        |         |           | Packaging 3 - 30 - B4B |                |
|                |        |         |           | Packaging 3 - 31 - B4B |                |
|                |        |         |           | Packaging 3 - 32 - B4B |                |
|                |        |         |           | Packaging 3 - 33 - B4B |                |
|                |        |         |           | Packaging 3 - 34 - B4B |                |
|                |        |         |           | Packaging 3 - 35 - B4B |                |
|                |        |         |           | Packaging 3 - 36 - B4B |                |
| 140 QC 21 - SA | 24 pcs | 6/14/19 | 0.00 0.00 | QC 21 - SA - 21        | DAS            |
|                |        |         |           | QC 21 - SA - 70        | 21 JUN 18 2019 |
|                |        |         |           | QC 21 - SA - 53        | 9-89           |

Part Op **110** - 1-Cut RBE703A95-0508-00-9 as per drawing sheet 4. 2-Cut RBE703A95-0505-00 -13 as per drawing sheet 5. 3-Descriptions: Assemble as per drawing note 7 and 8. 4-Pack as per drawing.

**120** - (QC5- Inspect part completeness to step on W/O)

**130** - (Identify as per dwg & Stock Location: \_\_\_\_\_)

**140** - (QC21- Final Inspection - Work Order Release)

### Job BOM

| Part / Item         | Component Name                   | Quantity           | Operation         | Container       |
|---------------------|----------------------------------|--------------------|-------------------|-----------------|
| 2044T47             | Tube Ø1.09                       | 9.6000 ft (.4 ea)  | 110-Small Fab - 1 | 5152113         |
| 2044T67             | Cap Ø1.09                        | 48 Ea (2 ea)       | 110-Small Fab - 1 | 5013300 28x5153 |
| 9263K173            | O-Ring                           | 24 Ea (1 ea)       | 110-Small Fab - 1 | 5172679         |
| PAD210              | Foam Ø1 X 1 replace item 1887T48 | 1.9200 sf (.08 ea) | 110-Small Fab - 1 | 3021250         |
| RBE703A95-0508-00-1 | Quill                            | 24 Ea (1 ea)       | 110-Small Fab - 1 | 5184991         |

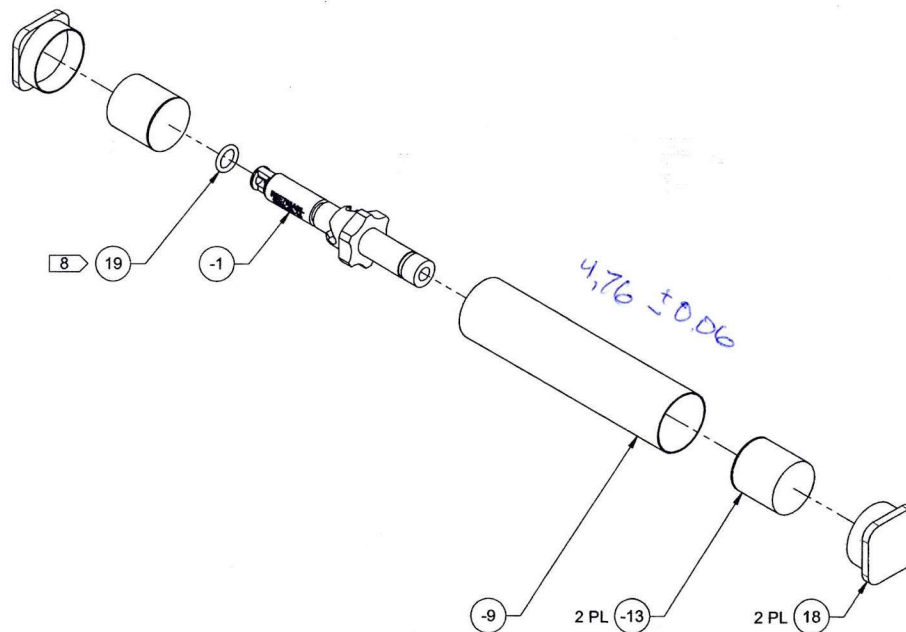
### Job Allocations

| Operation         | Component Part      | Required | Inventory | Allocated |
|-------------------|---------------------|----------|-----------|-----------|
| 110-Small Fab - 1 | 2044T47             | 10       | 37        | 0         |
|                   | 2044T67             | 48       | 168       | 0         |
|                   | 9263K173            | 24       | 44        | 0         |
|                   | PAD210              | 2        | 12        | 0         |
|                   | RBE703A95-0508-00-1 | 24       | 24        | 0         |

### Part Specifications

Specifications could not be found.

| ITEM # | QTY | PART #                      | PART TITLE                                   |
|--------|-----|-----------------------------|----------------------------------------------|
| -1     | 1   | RBE703A95-0508-00-1         | QUILL                                        |
| -9     | 1   | RBE705A95-0508-00-9         | TUBE                                         |
| -13    | 2   | RBE703A95-0508-00-13        | FOAM                                         |
| 18     | 2   | McMaster#2044T67 OR EQUIV.  | VINYL END CAP FOR 1.09" ID. SHIPPING TUBE    |
| 19     | 1   | McMaster#9263K173 OR EQUIV. | VITON O-RING 9 mm ID. X 13 mm OD. X 2 mm WD. |



# **RBE703A95-0508-00-15 MGB DRAIN TUBE QUILL ASSEMBLY**

## **NOTES:**

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X =  $\pm 0.1"$  /  $\pm 1^\circ$   
X.XX =  $\pm 0.01"$  /  $\pm 0.5^\circ$   
X.XXX =  $\pm 0.005"$  /  $\pm 0.1^\circ$   
X.XXXX =  $\pm 0.0005"$  /  $\pm 0.05^\circ$   
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY MOLYKOTE 55 OR EQUIVALENT ON ITEM 19 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS

|                |     |                                                                                                                                                                                                                                                                                                                                                                                                                                            |              |
|----------------|-----|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN         | KPT | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA<br><br>TOOL PART #<br><b>RBE703A95-0508-00</b><br>TITLE<br><b>MGB DRAIN TUBE</b><br><br><small>COPYRIGHT © 2019 BY DART AEROSPACE LTD<br/> THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | REV. J       |
| DRAWN          | KPT |                                                                                                                                                                                                                                                                                                                                                                                                                                            | SHEET 2 OF 6 |
| CHECKED        | MBB |                                                                                                                                                                                                                                                                                                                                                                                                                                            |              |
| MFG. APPR.     | DP  |                                                                                                                                                                                                                                                                                                                                                                                                                                            |              |
| APPROVED       | VK  | SCALE<br>NTS                                                                                                                                                                                                                                                                                                                                                                                                                               |              |
| DATE 2/25/2019 |     |                                                                                                                                                                                                                                                                                                                                                                                                                                            |              |